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[書類名] 図面

【図1】

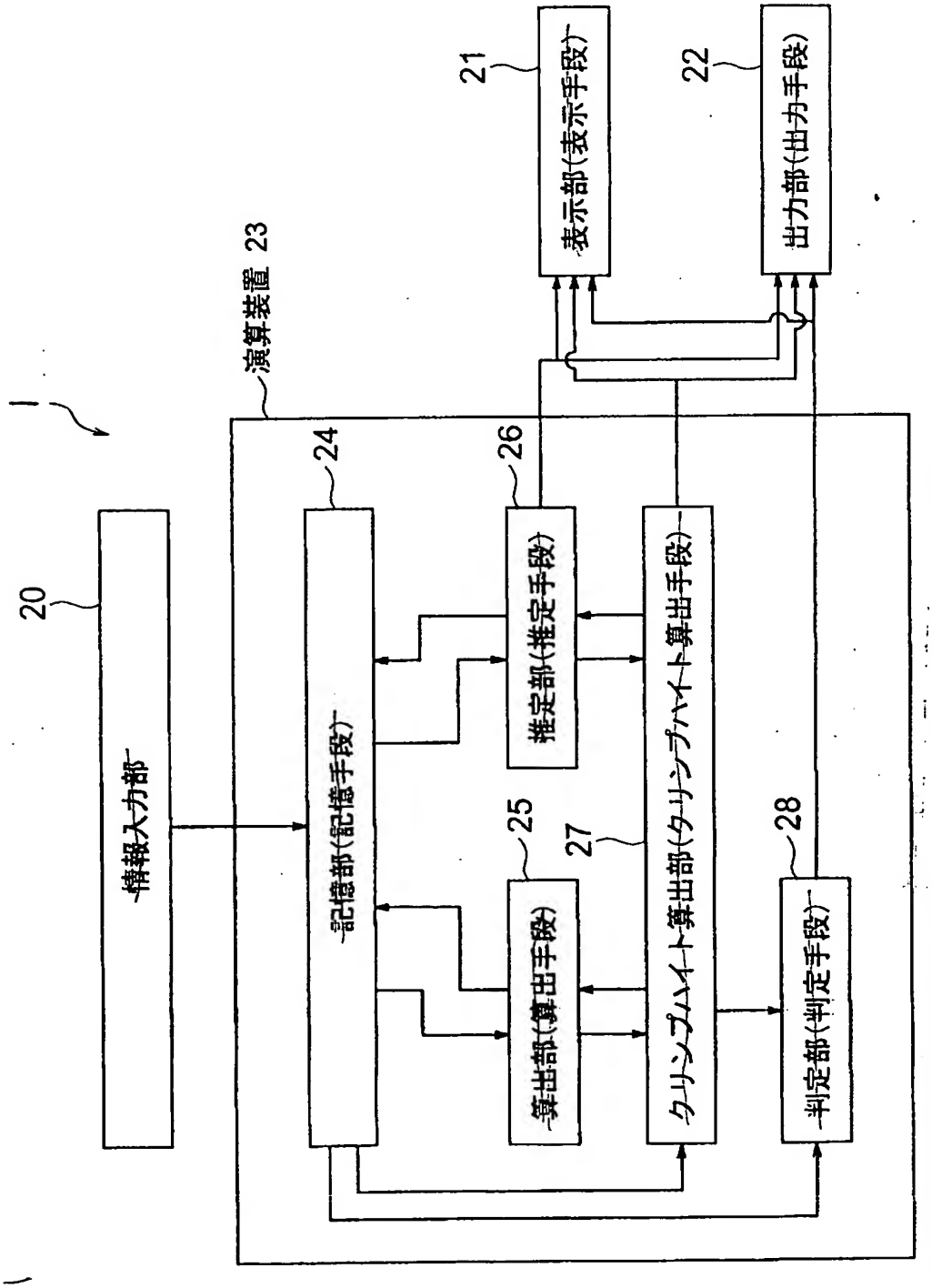

FIG. 1

20 INFORMATION INPUT SECTION
21 DISPLAY SECTION
22 OUTPUT SECTION
23 PROCESSING UNIT
24 STORAGE SECTION
25 CALCULATION SECTION
26 ESTIMATION SECTION
27 CRIMP HEIGHT CALCULATION SECTION
28 DETERMINATION SECTION

【図２】

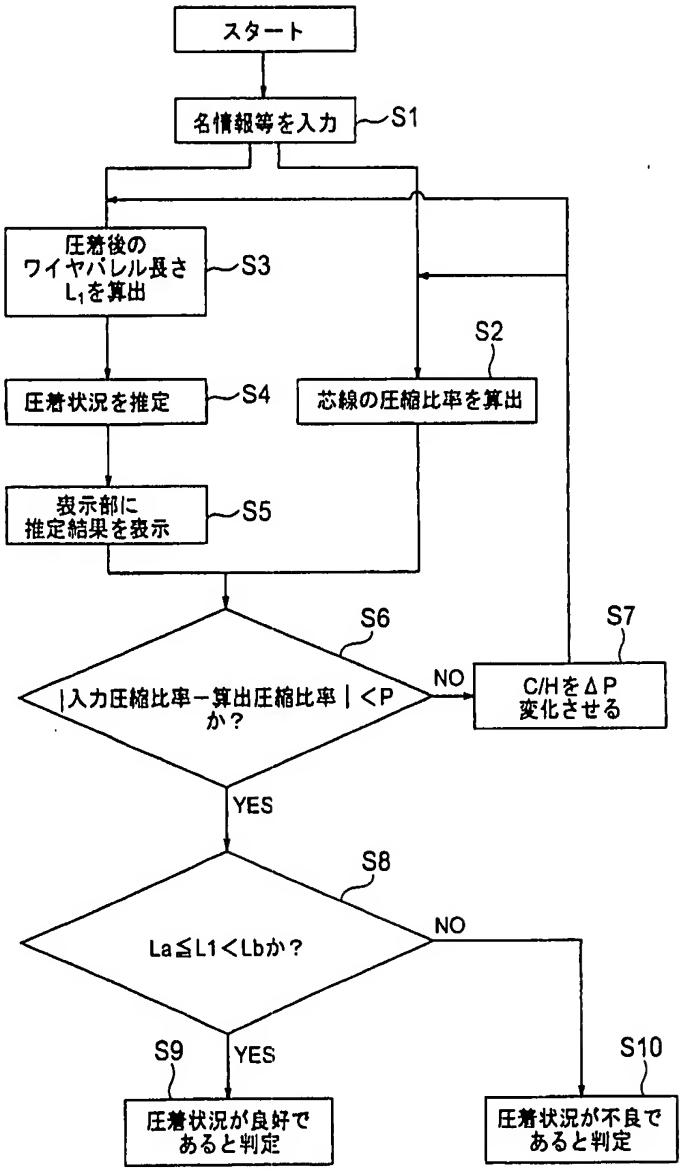

FIG. 2

START

S1 INPUT INFORMATION, ETC.

S2 CALCULATE COMPRESSION RATIO OF CORE WIRE

S3 CALCULATE WIRE BARREL LENGTH AFTER CRIMP, L_1

S4 ESTIMATE CRIMP STATE

S5 DISPLAY ESTIMATION RESULT ON DISPLAY SECTION

S6 |INPUT COMPRESSION RATIO - CALCULATED COMPRESSION RATIO| < P?

S7 CHANGE C/H ΔP

S8 La ≤ L1 < Lb?

S9 DETERMINE THAT CRIMP STATE IS GOOD

S10 DETERMINE THAT CRIMP STATE IS BAD

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[図3]

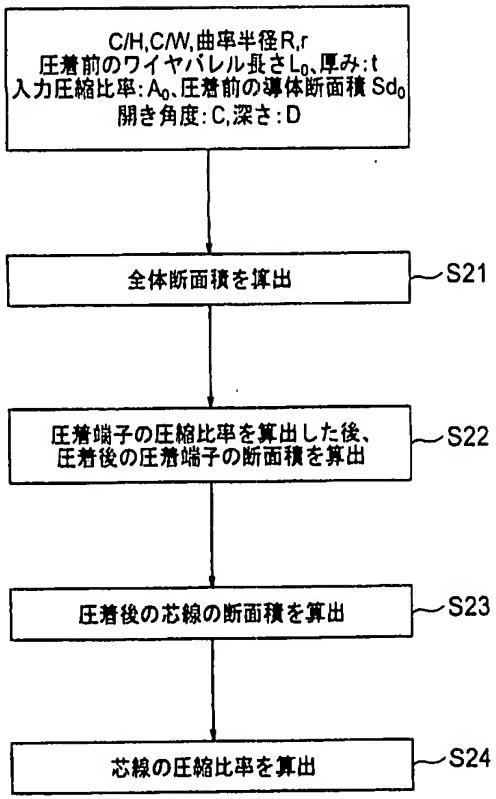

FIG. 3

C/H, C/W, CURVATURE RADIUSES R AND r

WIRE BARREL LENGTH BEFORE CRIMP, L_0, THICKNESS t

INPUT COMPRESSION RATIO A_0, CONDUCTOR CROSS-SECTIONAL AREA BEFORE CRIMP, Sd_0

APERTURE ANGLE C, DEPTH D

S21 CALCULATE TOTAL CROSS-SECTIONAL AREA

S22 CALCULATE COMPRESSION RATIO OF CRIMP CONTACT TERMINAL AND THEN CALCULATE CROSS-SECTIONAL AREA OF CRIMP CONTACT TERMINAL AFTER CRIMP

S23 CALCULATE CROSS-SECTIONAL AREA OF CORE WIRE AFTER CRIMP

S24 CALCULATE COMPRESSION RATIO OF CORE WIRE

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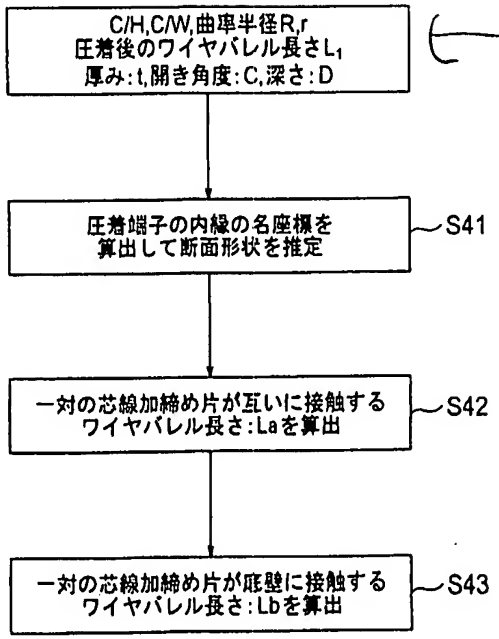
[図4]

Fig.4



C/H, C/W, CURVATURE RADIUSES R AND r

WIRE BARREL LENGTH AFTER CRIMP, L_1,

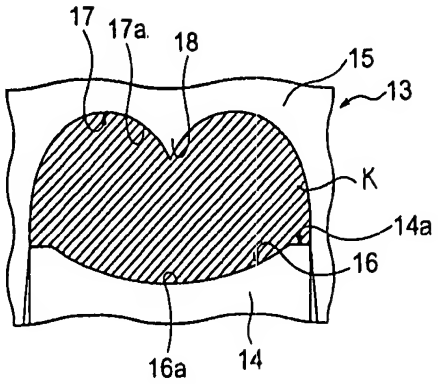
THICKNESS t, APERTURE ANGLE C, DEPTH D

S41 CALCULATE COORDINATES OF INNER MARGIN OF CRIMP CONTACT TERMINAL AND ESTIMATE CROSS-SECTIONAL SHAPE

S42 CALCULATE WIRE BARREL LENGTH La APPLIED WHEN PAIR OF CORE WIRE CRIMP PIECES IS IN CONTACT WITH EACH OTHER

S43 CALCULATE WIRE BARREL LENGTH Lb APPLIED WHEN PAIR OF CORE WIRE CRIMP PIECES IS IN CONTACT WITH BOTTOM WALL

Fig.5



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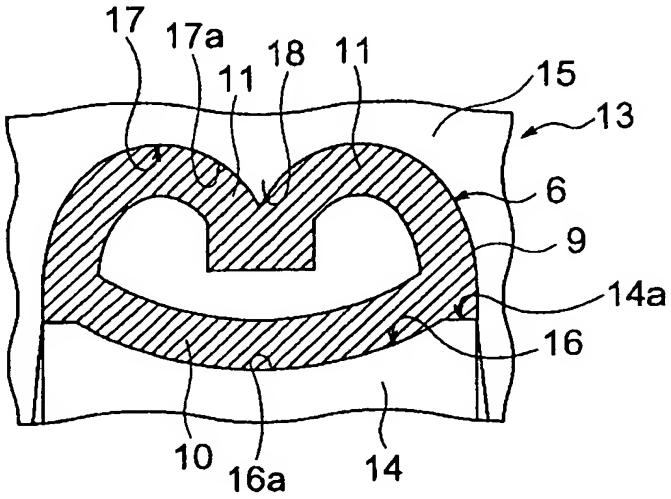
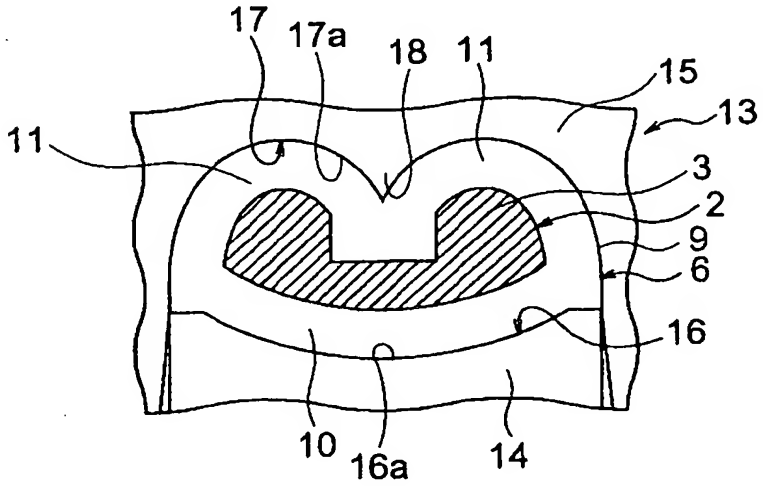
[図6] Fig. 6



[図7] Fig. 7



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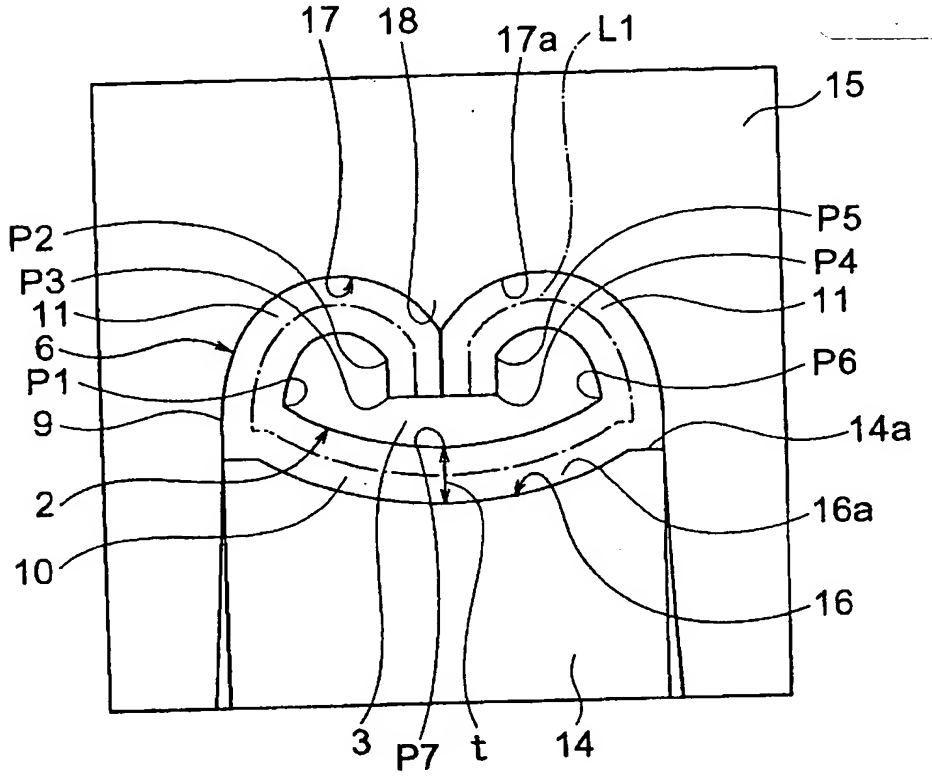
[図8] Fig. 8



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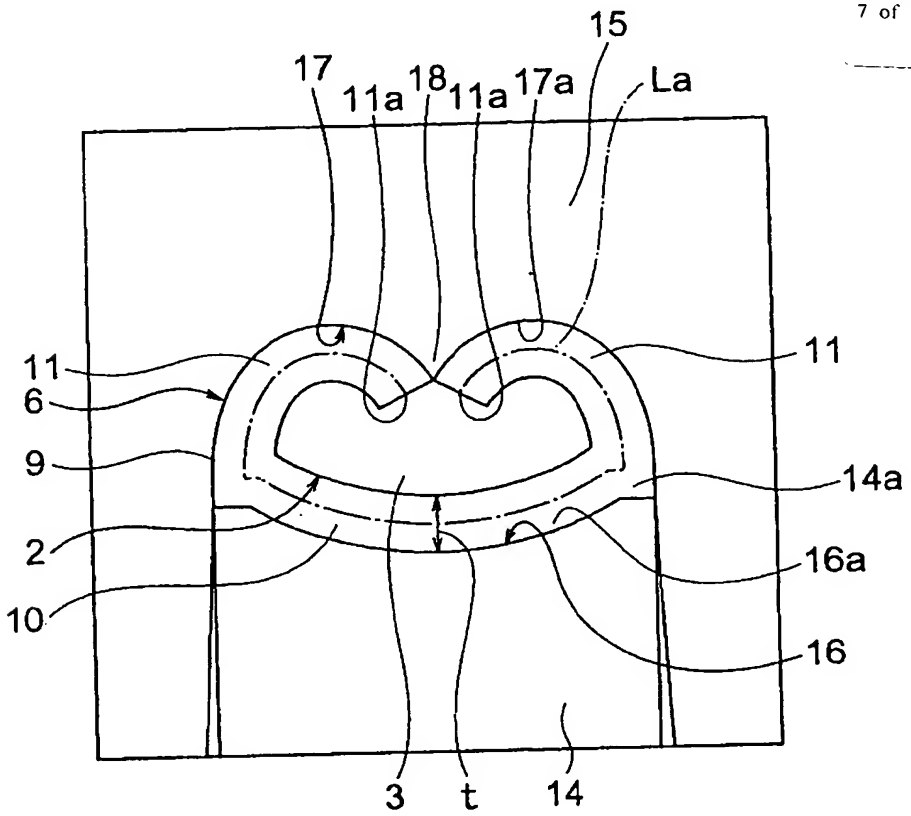
[図9] Fig. 9



[図10] Fig.10

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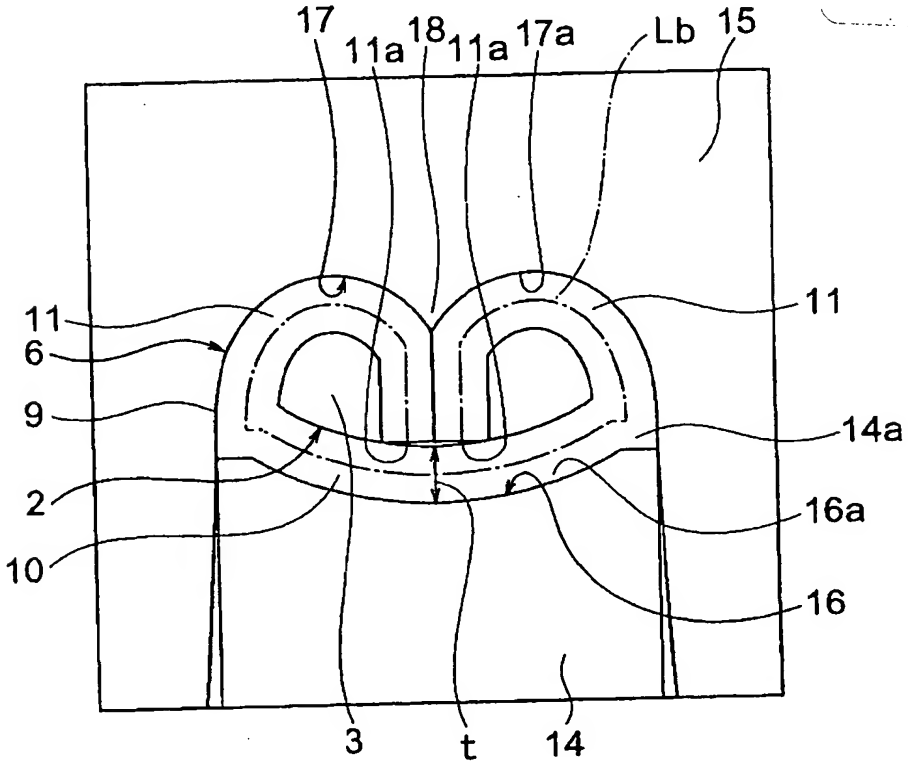
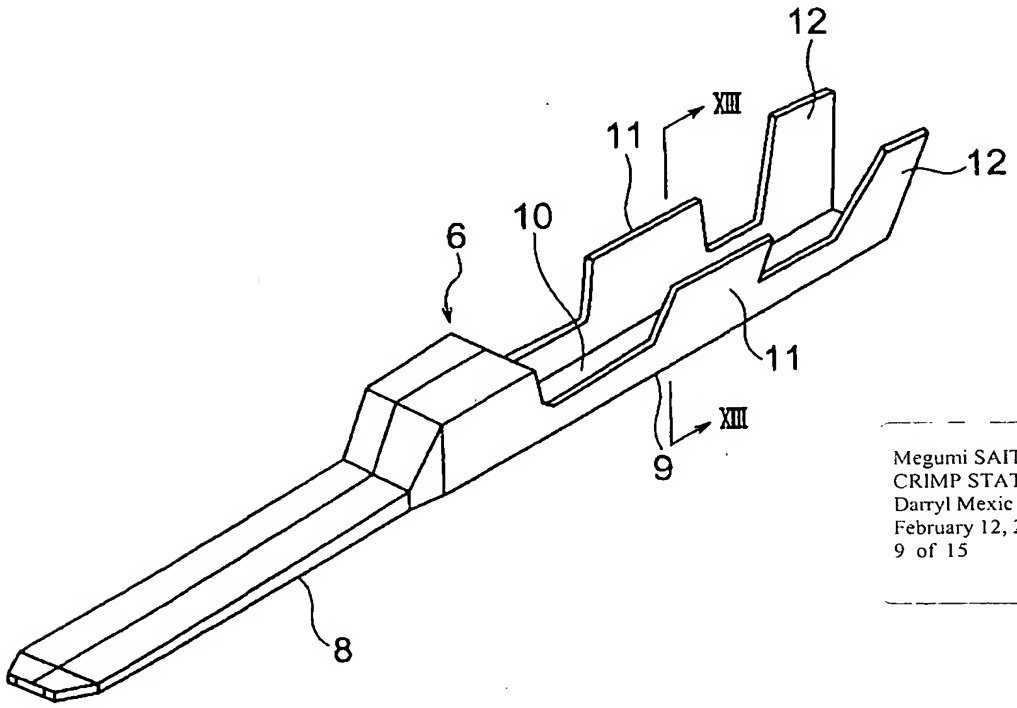


[図11] Fig. 11



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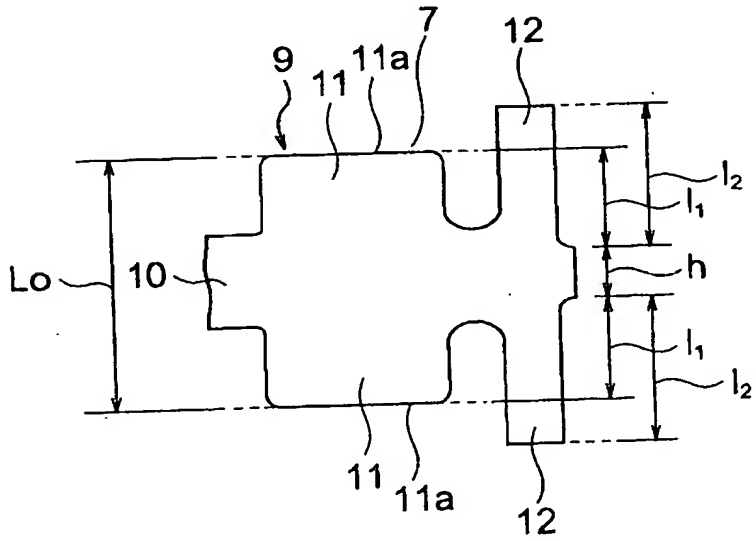
[図12] Fig. 12



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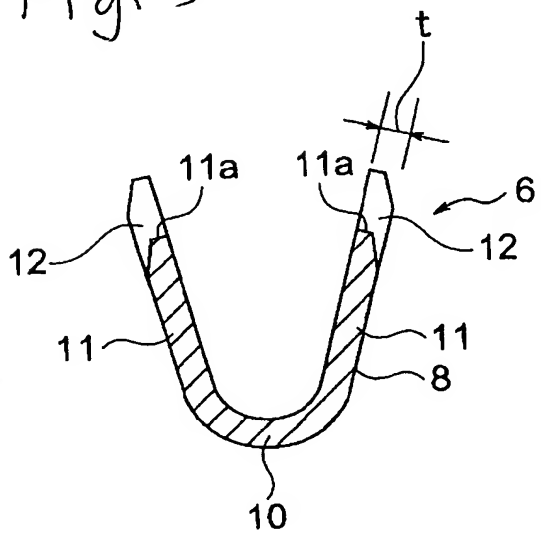
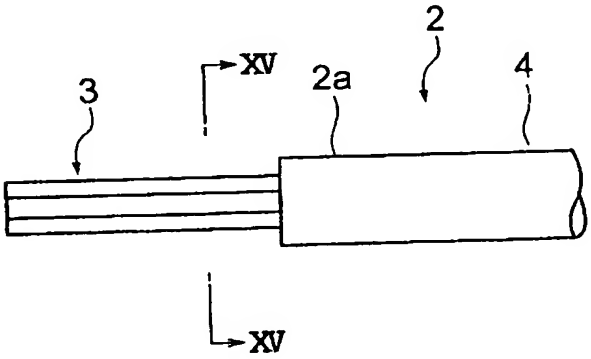
[図13]

Fig.13



[図14]

Fig.14



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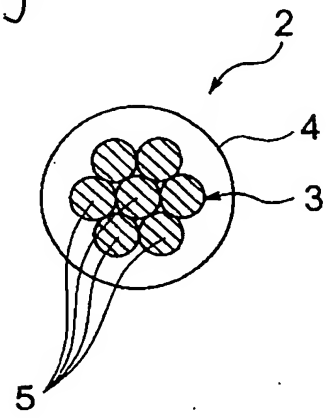
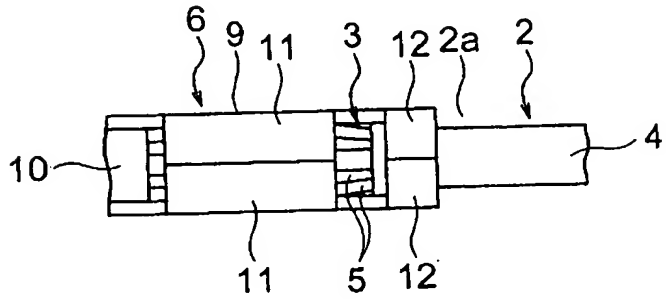
[図15]

Fig.15



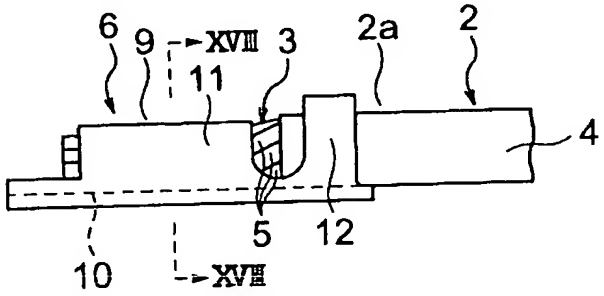
[図16]

Fig.16



[図17]

Fig.17



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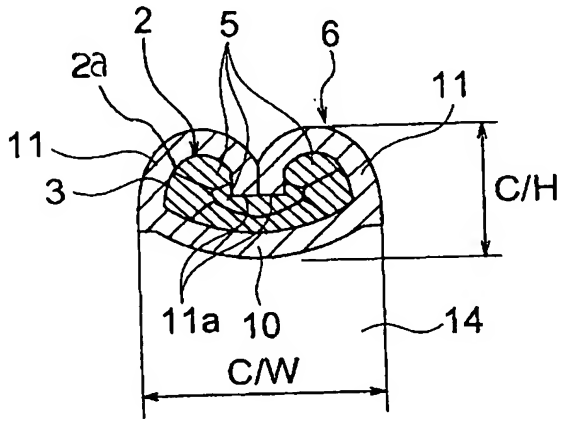
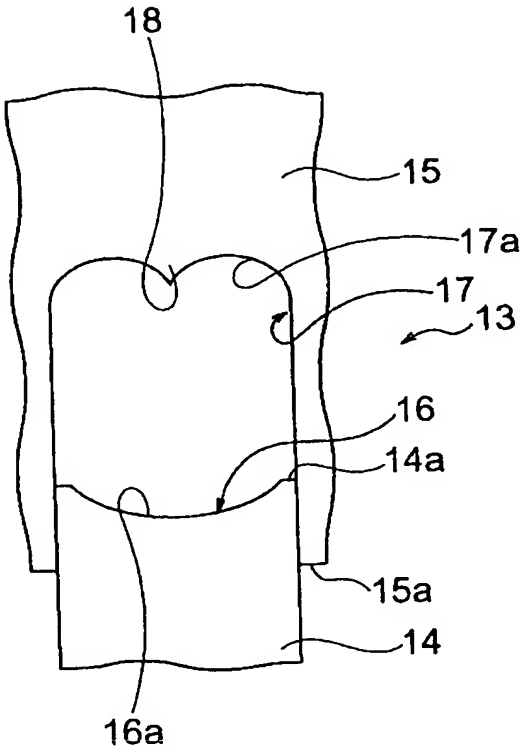
[図18]

Fig. 18



[図19]

Fig. 19



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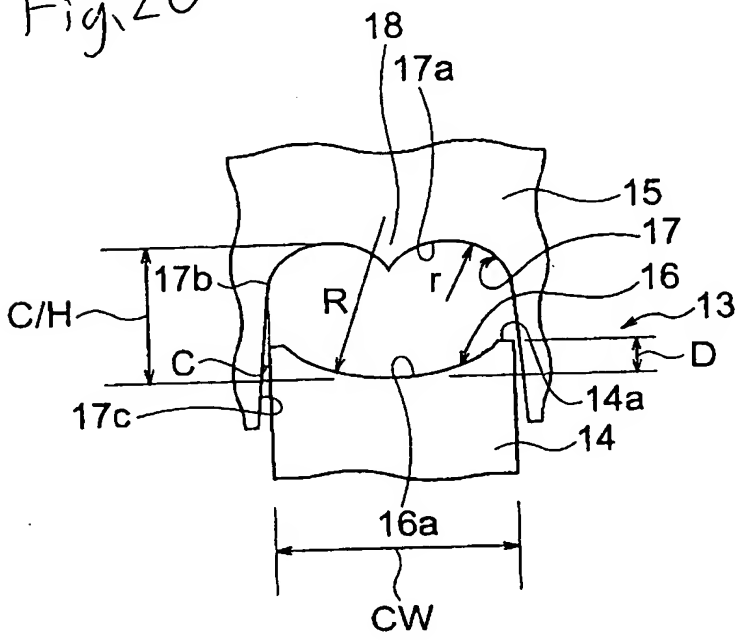
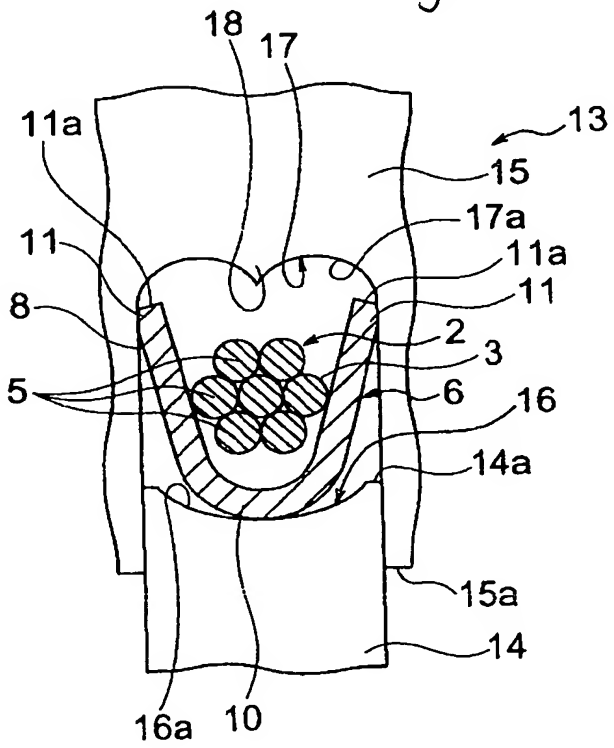
【図２０】

Fig.20



【図２１】

Fig.21



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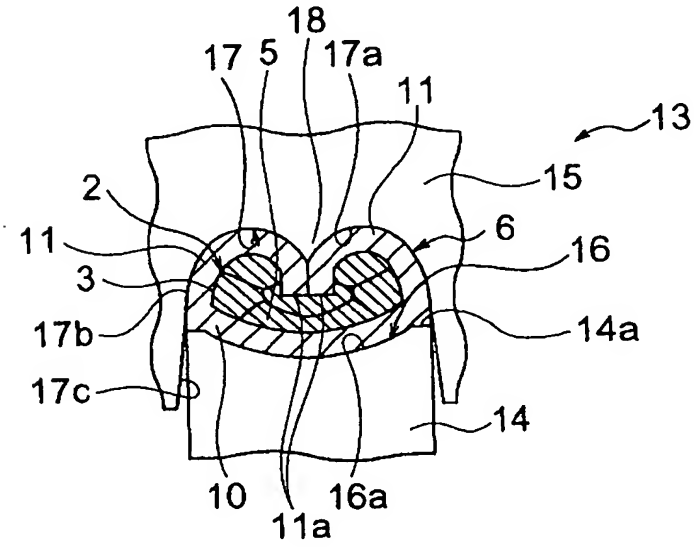
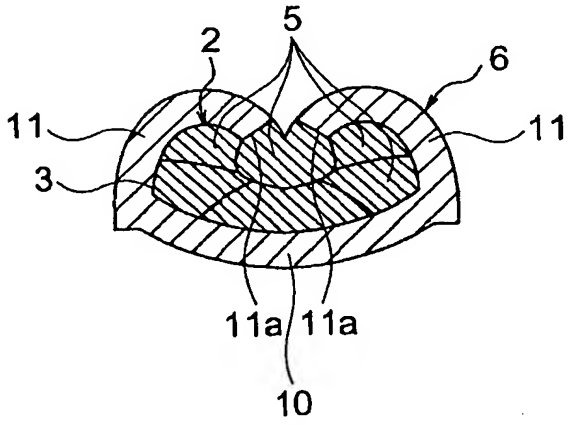
【図２２】

Fig.22



【図２３】

Fig.23



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【図24】
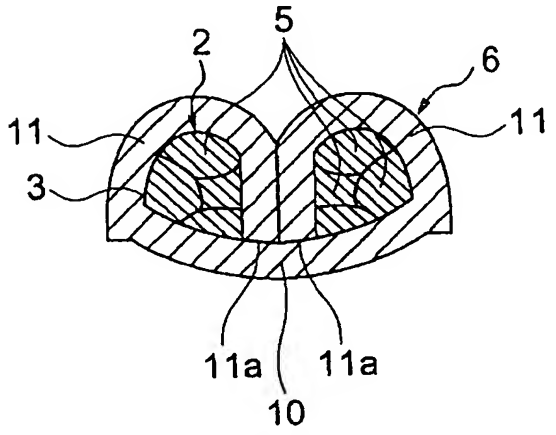
Fig. 24